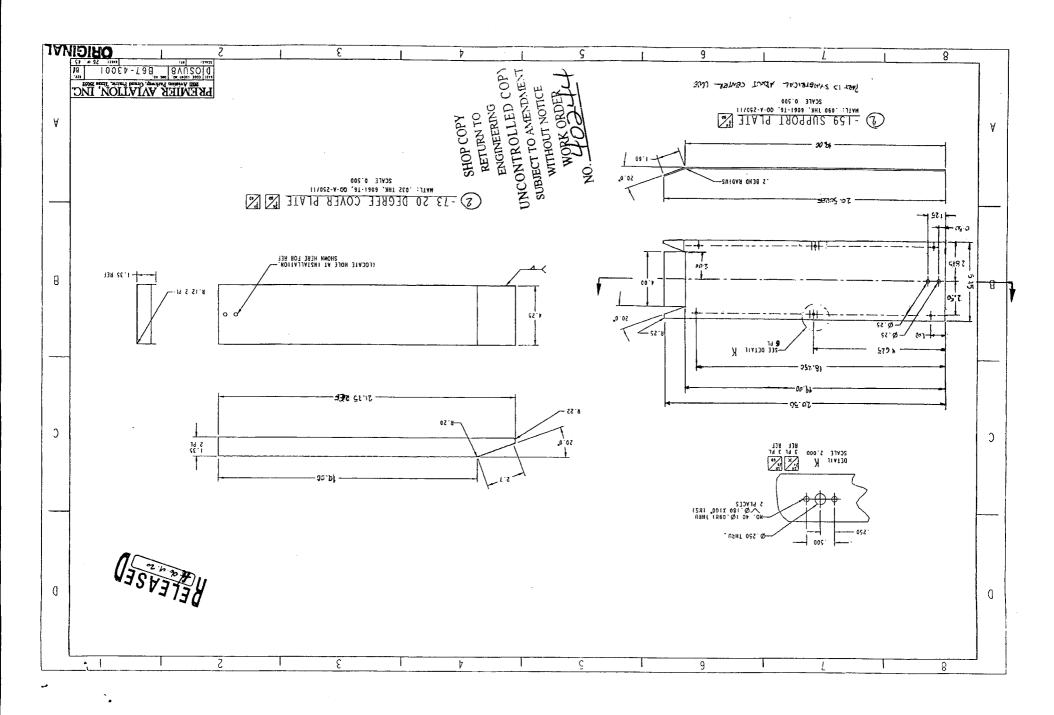
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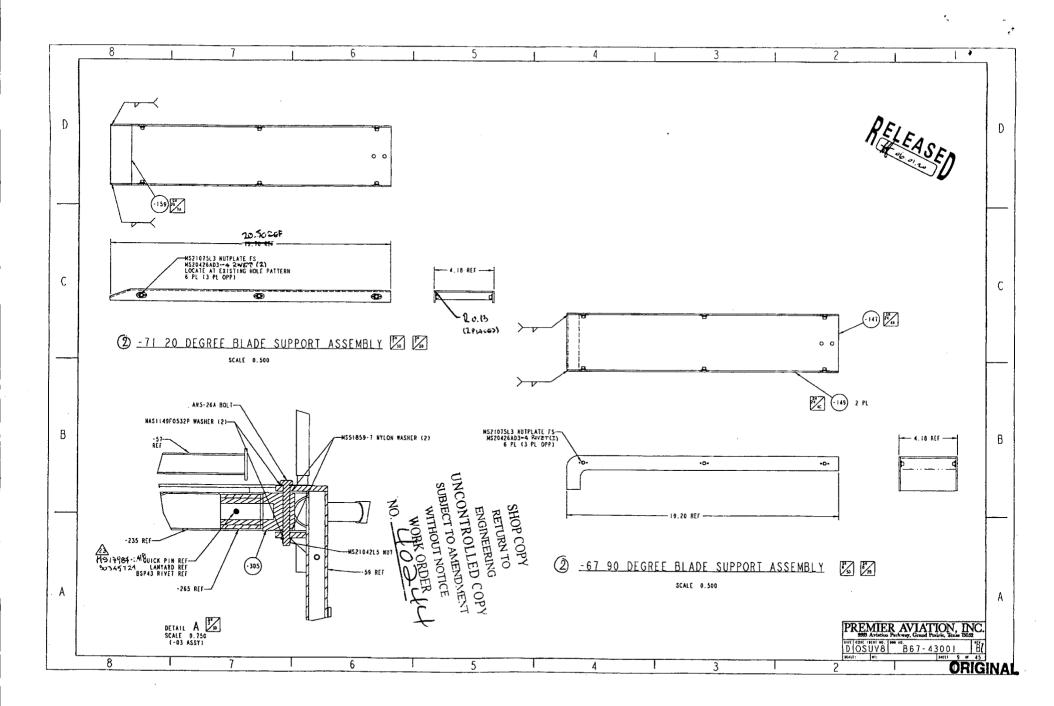
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Date:

Friday, 7/4/2008 8:45:48 AM

Úser:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1 1-install nut plates as per dwg B67-43001

16.0

QC5

INSPECT WORK TO CURRENT STEP





Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

18.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Ae	rospace L	.td								
W/O:			W	ORK ORDER CH	ANGES				<u>.</u> .	<del></del>
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DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date		ion C	Chief Eng	QC Inspector
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Date: Friday, 7/4/2008 8:45:48 AM Úsěr: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SUPPORT PLATE J வ Number: 40244 Part Number: PB674300171 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1- weld as per dwg B67-43001 SMALL & MEDIUM FAB RESOURCE 1 8.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 08.01. 1-grind weld flush VISUAL INSPECTION OF GROUND WELDS 9.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS 10.0 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 11.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 13.0 MS21075L3 60.0000 Each(s) Comment: Qty.: 6.0000 Each(s)/Unit Total: Nutplate RIVET 14.0

Comment: Qty.:

RIVET

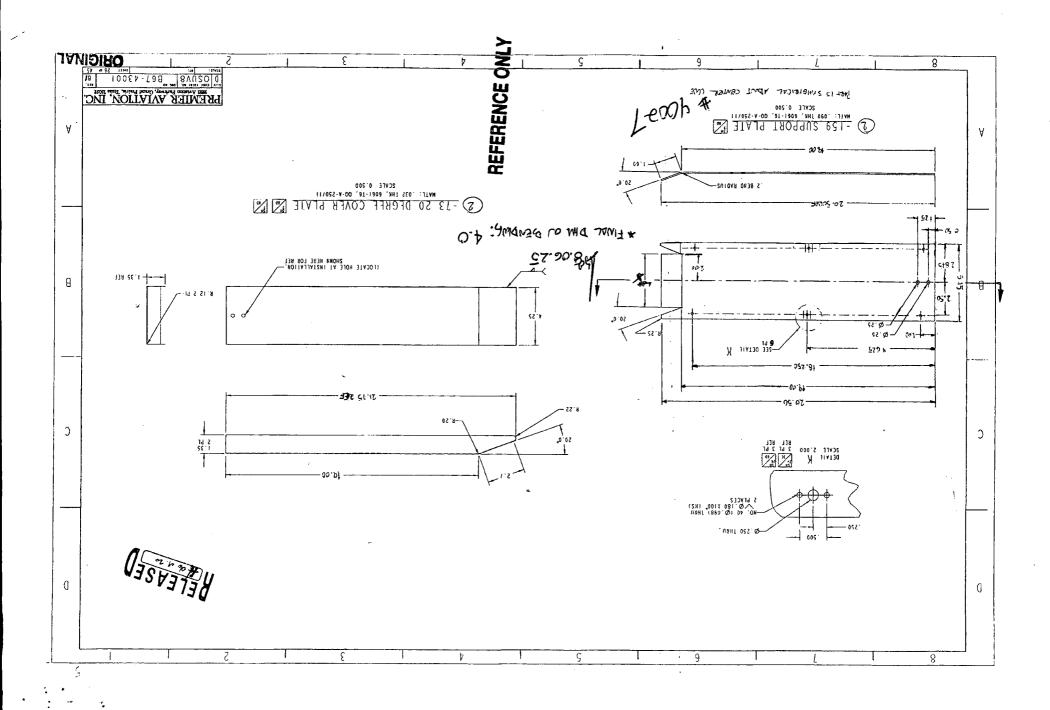
12.0000 Each(s)/Unit

Total: 120.0000 Each(s)

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Friday, 7/4/2008 8:45:48 AM Kim Johnston User: **Process Sheet Drawing Name** : SUPPORT PLATE : CU-DAR001 Dart Helicopters Services Customer Job Number : 40244 : 13385 **Estimate Number** : PB674300171 P.O. Number **Part Number** : 7/4/2008 S.O. No. : **Drawing Number** · B6743001 P.9/26 This Issue : N/A : NC Project Number Prsht Rev. ; B1 : SMALL /MED FAB : // First Issue Type **Drawing Revision** : 40027 Material Previous Run Qty: Each : 7/10/2008 10 Um: **Due Date** Written By Checked & Approved By DD verified by:ec see first page Comment : Est Rev:A 08-06-19 new issue procedure chg DD vrified by:EC 08-06-27 Est Rev:B **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: M6061T6S090 6061-T6 .090 Sheet 1.0 Comment: Qty.: 0.8594 sf(s)/Unit Total: 8.5943 sf(s) 6061-T6 .090 Sheet batch: FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-159 Dwg Rev: Prog Rev: \*\*\*\*grain direction along 5.750" \*\*\*\* 2-Deburr if necessary 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK NC BRAKE 5.0 BRAKE NC Comment: NC BRAKE Bend as per Dwg B67-43001



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Date: User:

Tuesday, 24/06/2008 1:02:21 PM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



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Seq. #:

**Machine Or Operation:** 

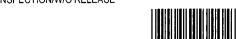
Description:

14.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

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Job Completion



h 08.08.01

W/O:		WORK ORDER CHANGES									
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		* All permenent change	M	08/06/27			6				

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Date: Tuesday, 24/06/2008 1:02:21 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SUPPORT PLATE Job Number: 40027 Part Number: PB6743001159 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 08.06.27 1- weld as per dwg B67-43001 8.0 Nutplate Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s) Nutplate MS20426AD34 Comment: Qty.: 12.0000 Each(s)/Unit @ Total: 60.0000 Each(s) **RIVET** 10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 -1-crind-wold-flash -install nut plates as per dwg B67-43001 Comment: -VISUAL-INSPECTION OF GROUND WELDS 12.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 13.0 PACKAGING : Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_\_\_\_\_\_\_\_

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Tuesday, 24/06/2008 1:02:21 PM Date: User: Linda Lacelle **Process Sheet** : SUPPORT PLATE Custorer : CU-DAR001 Dart Helicopters Services **Drawing Name** Job Number : 40027 : 13385 **Estimate Number** P.O. Number Part Number : B6743001 PAGE26 : 24/06/2008 **Drawing Number** This Issue S.O. No. : : N/A Prsht Rev. : NC **Project Number** : // : SMALL /MED FAB : B1 First Issue Type **Drawing Revision** Previous Run Material Due Date : 01/07/2008 Written By Checked & Approved By Comment : Est Rev:A 08-06-19 new issue DD verified by:ec **Additional Product** Job Number: Seq. #: **Machine Or Operation:** Description: 1.0 M6061T6S090 6061-T6 .090 Sheet Comment: Qty.: 0.8594 sf(s)/Unit Total: 6061-T6 .090 Sheet 2.0 Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-159
Dwg Rev: \$1 43001-159 Dwg Rev:\_ Prog Rev:\_ \*\*\*\*grain direction along 5.750" \*\*\*\* 1B 8-6-34
INSPECT PARTS AS THEY COME OFF MACHINE 2-Deburr if necessary 3.0 QC2 HB 8-6-24 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 Comment: SECOND CHECK 5.0 BRAKE NC NC BRAKE Comment: NC BRAKE Bend as per Dwg B67-43001 ounterinit asperduq

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